

Date: Tuesday, 10/2/2007 1:25:19 PM
 User: Kim Johnston

Process Sheet

44

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID RH 206L1,L3,L4&407
Job Number	: 34963		
Estimate Number	: 10328		
P.O. Number	:	Part Number	: D206642512
This Issue	: 10/2/2007 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: K
Previous Run	: 34962	Material	:
Written By	:	Due Date	: 10/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>10-7-10-02</u>		
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM		
	: Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM		
	: est rev D 07.06.06 added K642-512 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-512 CHG003

2.0	34963A	FLOAT SKIDTUBE ASSEMBLY
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Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-541 B 34963A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K642 512	saddle kit 642-511
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

saddle kit 642-512

batch: 334626

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

B 34963A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 1:25:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID RH 206L1,L3,L4&407

Job Number: 34963

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-512

Location:

02/11/13 (1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.11.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

512

Dart Aerospace Ltd.

44

Date: Tuesday, 10/2/2007 1:26:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE ASSEMBLY
 Job Number : 34963A
 Estimate Number : 10309
 P.O. Number :
 This Issue : 10/2/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D206642541
 First Issue : 1 / Type : LANDING GEAR Drawing Number : D3274 REV D
 Previous Run : 34962A Material :
 Written By : Due Date : 10/30/2007 Qty: 1 Um: Each
 Checked & Approved By : 7-10-02
 Comment : Est Rev:B 05-09-23 Revised per D206-642 Rev. J KJ/JLM
 Est Rev:C 07-02-23 Added SS-Wearplates & Gaskets JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A

2.0 D26001190 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-190 3" OD Tube

B31032

DP 7-10-15

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 7-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34963A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

JD 7-10-16

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/10/16

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/16

7.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B-347924 AWM 07-10-23

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

4-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

Start: 07-10-23

Finish: 07/10/24

(Adhere for 12 hours)

Time: 9:15

Time: 12:00 am

AWM 07-10-16

DP

AWM/DP 07-10-23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34963A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

*****Verify dimensions before and after cutting*****

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

5-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

6- Countersink crossbolt spacer holes as per Dwg D3274

EL/JR
7-10-24

SL/2 7-10-25

DP
7-10-25

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL/2 7-10-25

12.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3285-1

Fwd Cap

B33902

BE 07-10-30

13.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

B34612 (7P)

B34508 (5P)

BE 07/10/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: JD Date: 02/11/15
 QA: N/C Closed: _____ Date: _____

NCR: <u>34963A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-25	10.1	Upon inspection, the fuel cut was found to be 1" MAX short on the length, the height is good. R.C. fuel section was slightly over bent, machine	CP 07.10.25 per Q51042	Acceptable. Shorter front section is stronger, so not a strength issue	N/A 7	CP 07.10.25 per Q51042	CP 07.10.25 per Q51042	CP 07-10-25

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34963A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description:

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1

Crossbolt spacer

234619 BE 07/10/30

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod

M 105138 BE 07/10/30

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

M 105138 BE 07/10/30

3-Grind welds flush to Fwd cap on top surface only.

BE 07/10/30

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

SL/DP 7-10-31
7-12-31

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/10/01

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 07-10-31

18.0

POWDER COATING

POWDER COATING



M105914



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 07/11/05
PRESSURE WASH BE 07/11/05

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-11-06

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34963A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate B33842 *HL*

21.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet M103525 *HL*

22.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet M15918 * *HL*

23.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Insert

Batch: M105279 * *HL*

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/RN/ALPS-3 M105005

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R Sikaflex-291 M185585Sikaflex expire date: 08-07 *HL* 07-11-06 *(C)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Date: Tuesday, 10/2/2007 1:26:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34963A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts

6-7/10/08

26.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)
BOLT
Batch: M105559

YH

27.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B34624

Y1

28.0

D353523

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B35218

Y1

29.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B34883

Y1

30.0

D353539

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B35257

Y7

31.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B33964

YJ

07-11-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34963A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

32.0

D353623

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B33965

JA

33.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B34828

JA

34.0

D353639

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B33966

JA

35.0

D35371

WEARPAD



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

WEARPAD

Batch: B34943

JA

36.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD

Batch: B33285

JA

37.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer M105143

JA

38.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 NAS1515H3L

Washer M105116

JA 07-11-06

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34963A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B33949 *MF*

40.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M18918 *YL*

41.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer M100993 *YL*

42.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B31335 *YL*

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

✓ A/R Sikaflex-291 M105585

Sikaflex expire date: 08-07

✓ 4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

✓ A/R LPS-3 Batch: M105005

✓ 6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

JP 07-11-06 *Q*

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

A/R Sikaflex-291

M103585

Sikaflex expire date:

08-07

9A

09-11-06

①

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 071107

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location:

PPP 34963

07/11/13

46.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.15

9A

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.11.14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
				5				

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED**07.02.12** **[Signature]**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

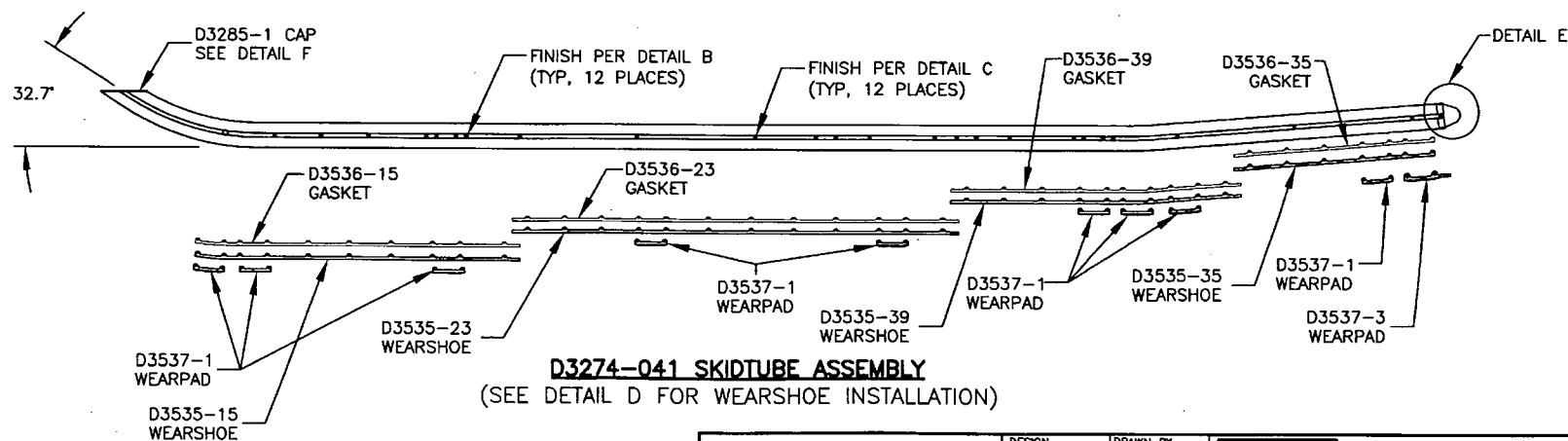
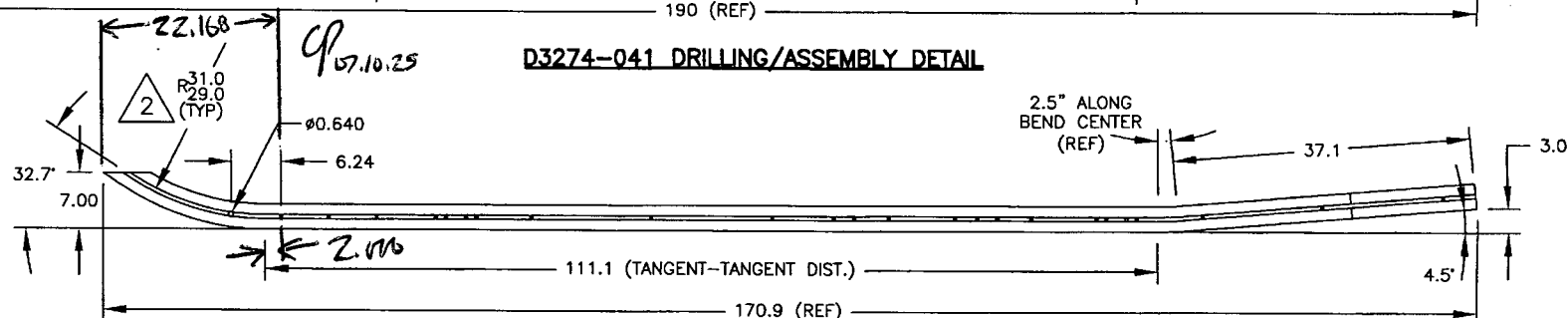
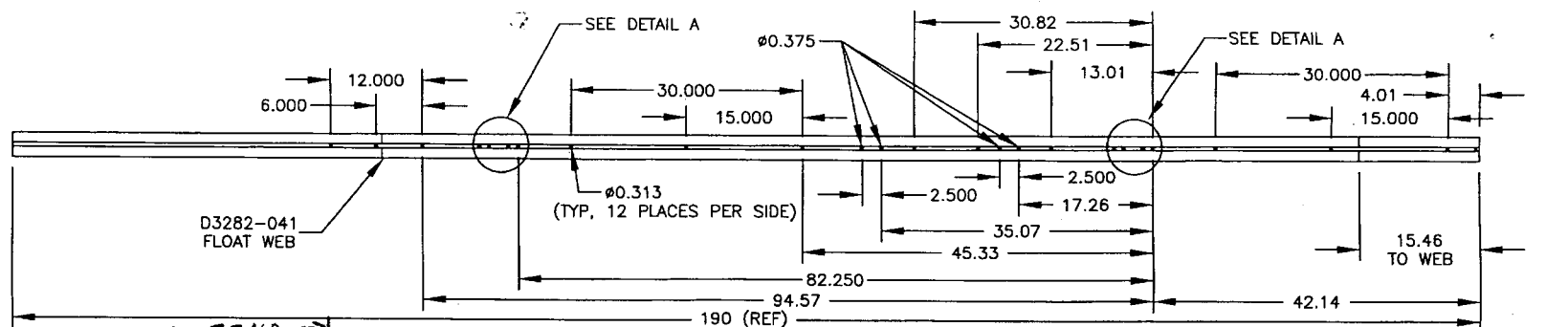
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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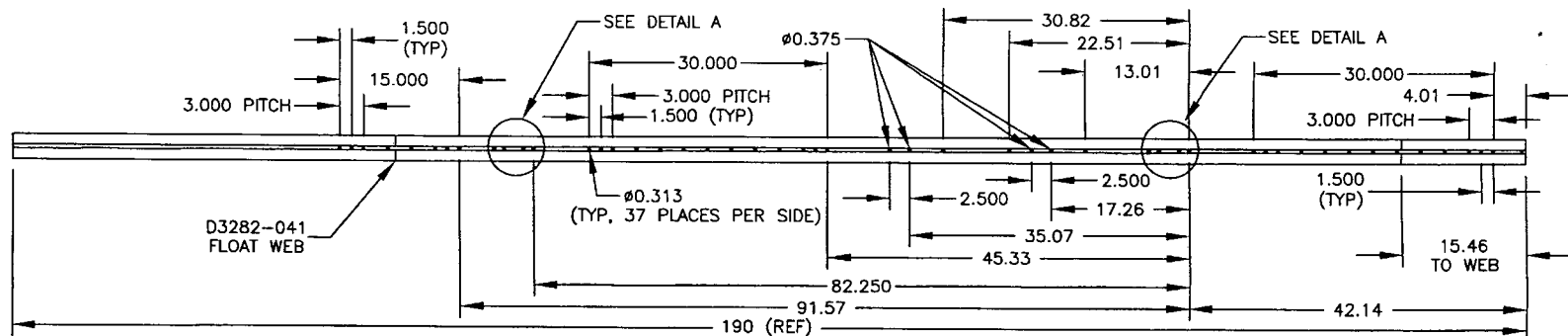
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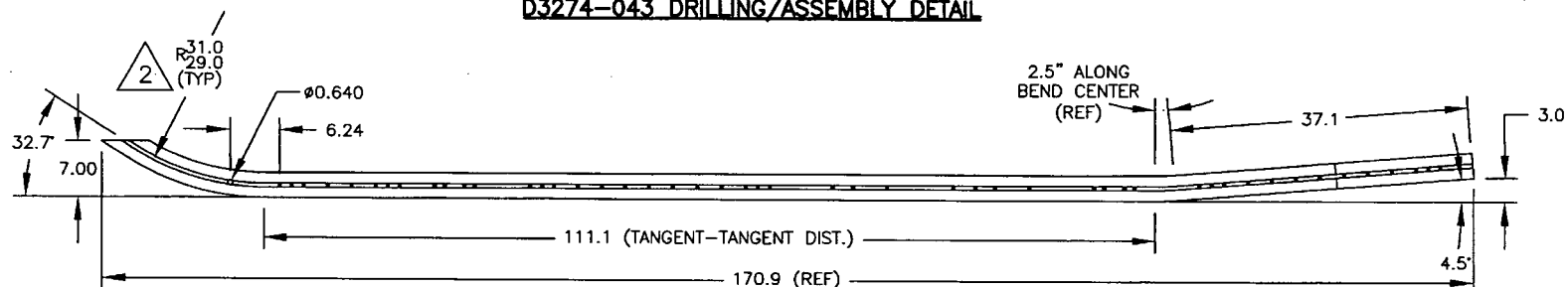
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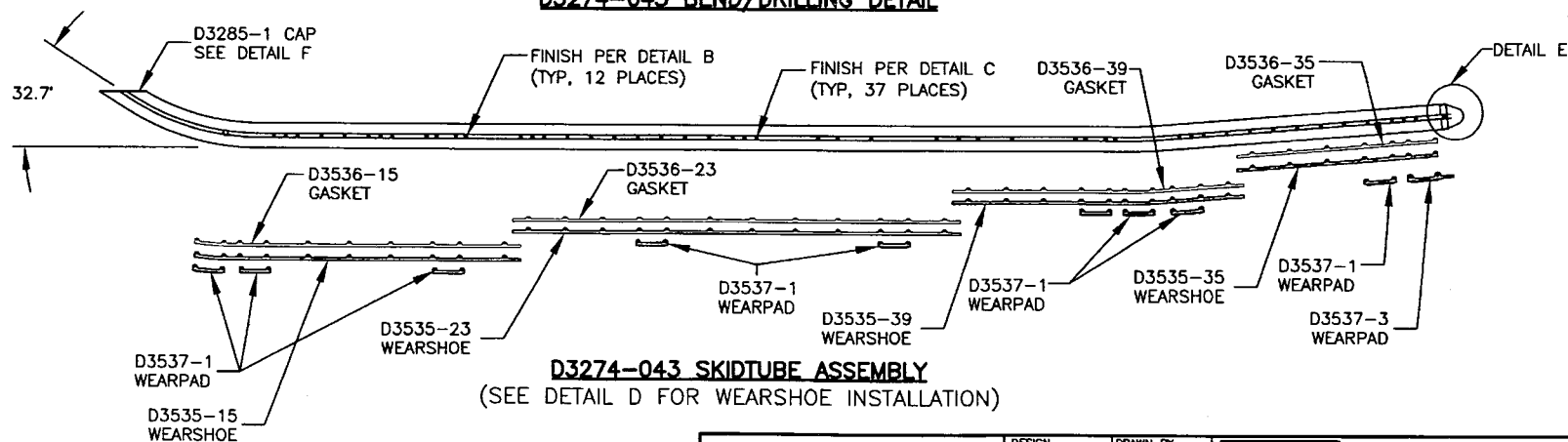
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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:15	



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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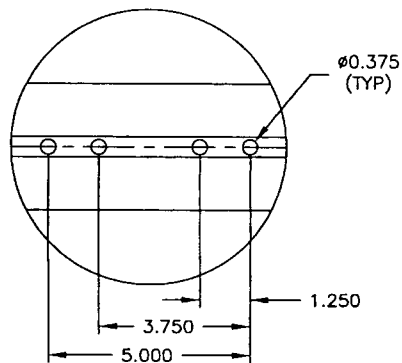
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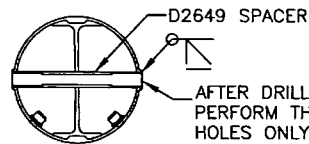
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CHECKED H	APPROVED H	DRAWING NO. D3274	SHEET 3 OF 4
DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY	SCALE 1:15	

DETAIL A: DRILL DETAIL

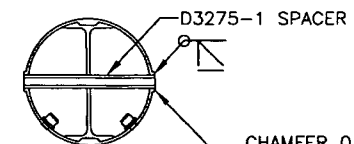


DETAIL B FOR 0.375 HOLES ONLY



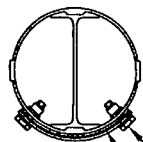
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

- AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291

DETAIL E

- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP

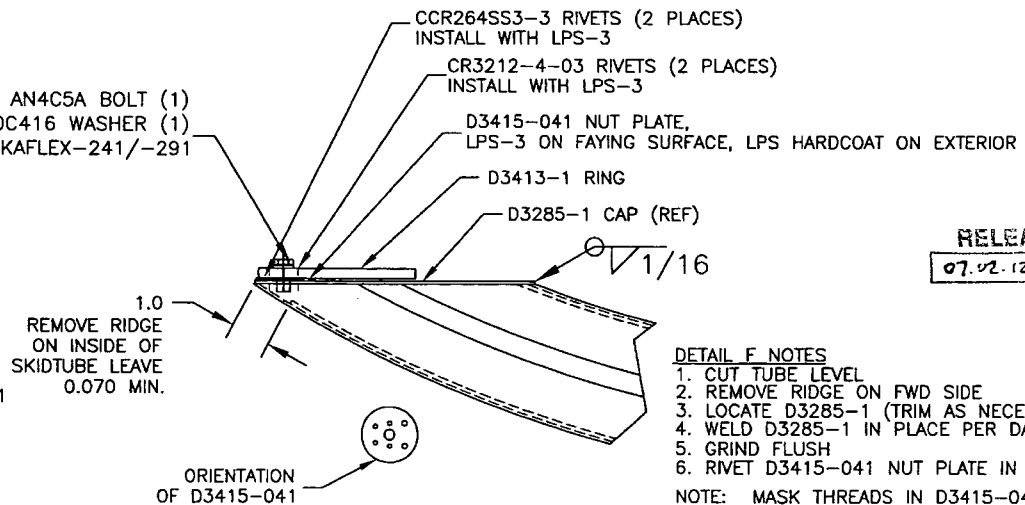
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

0.400

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DATE 06.12.19	DRAWING NO. D3274		SHEET 4 OF 4	
TITLE SKIDTUBE ASSEMBLY			SCALE 1:3	

NO. 131

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Barclay Elliot
Joint Welding Procedure tig
Part number and Job number DD206 412 541 / B34772

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input checked="" type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-10-19 Qualifier Pat. Durl